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<b>Work Ord</b> Monday, Novem												Page 1
Item ID: Revision ID:	D3436-044	:		Accept					Setup	Start Stop		
Item Name: Start Date: Required Date: Reference:	Step RH 11/15/2010 11/22/2010	Start Qty: 2.00 Req'd Qty: 2.00	: 1881/4 1/80 / 886 1 / 88/4 1/80 / 88/		Cust Item I Customer:	D:		•		эгор		
Approvals:	Process Pla	n:	Date://///5	Tooling: SPC (Y/N):		ate:		I	Run	Start Stop		
Sequence ID/ Work Center II	D	Operation Description	<u>·                                      </u>	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr	· · · · · ·	,						<del></del>	+	
D3436	Rev	A										
		Large Fab		0.00				157	, '		~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~	

0.00

Batch

Batch

□Batch

4130 Welding Rod | 100076

1600575

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and

4130 Welding Rod □ 1000 75

Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436□Dwg Rev:

4130 Welding Rod□

Memo

 $A/R \square N/A \square$ 

 $A/R \square N/A \square$ 

 $A/R \square N/A \square$ 

Qty□ Part Number□Description□

Qty□ Part Number□ Description

Large Fab

Large Fab

								• *
W/O:			WC	RK ORDER CHANGI	ES			
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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## Work Order ID 63807

Monday, November 15, 2010 8:35:18 AM



Page 2

Item ID:

D3436-044

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: Step RH

11/15/2010

Start Qty: 2.00

**Required Date:** 11/22/2010 Req'd Qty: 2.00



**Cust Item ID: Customer:** 

Tool ID

Reference:

**Start Date:** 

Approval	s:
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Process Plan:

Date:

Tooling:

Date:

Run Start

Reject

R 11-1-24

Otv

Accept

**Oty** 



QC:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID

110

Bandsaw

Jeaspa Bandsaw

**Operation** 

Description

Set Up/ **Run Hours** 

0.00

**BAND SAW** 

0.00

1-Slit part D3436-041 on bandsaw as per Dwg D3436

2- deburr

Memo

Memo

120

OC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

BE (2) 11-01-24

130

Quality Control

QC5- Inspect part completeness to step on W/O

Sulo1/24

Dail AC	i Ospace L	.tu							k •
W/O:			WO	RK ORDER CHANG	ES	· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date (	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Res	solution:	Disposition	):	_ QA: N/C Clo	osed:		_ Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
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## Work Order ID 63807

Monday, November 15, 2010 8:35:18 AM



Page 3

Item ID:

D3436-044

Accept

Setup Start

Stop



Revision ID:

Item Name:

Step RH

11/15/2010 **Start Date:** 

Start Qty: 2.00

**Required Date:** 11/22/2010 Req'd Qty: 2.00



Date:\_\_\_\_\_

**Cust Item ID: Customer:** 

Tool ID

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_

QC:

Operation

**Description** 

Tooling:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Run Start

Reject

Qty

Accept

Qty

Stop

Reject

Number



Insp.

Stamp

Sequence ID/ **Work Center ID** 

140

Powdercoat

Powder Coating

START TIME: 3:40

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

OVEN TEMPERATURE:

0.00

0.00

Tool # Plan

Code

150

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

0.00

Small Fab

155

Memo

0.00

Small Fab

Bond pads per dwg and OSI 015

W/O:	T		W	ORK ORDER CHANGI	ES			
DATE	STEP	PRO	OCEDURE CHA		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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## Work Order ID 63807

Monday, November 15, 2010 8:35:18 AM



Page 4

Item ID:

D3436-044

Accept



Setup Start



**Revision ID:** 

Item Name:

Step RH

11/15/2010

Start Qty: 2.00

**Required Date: 11/22/2010** Req'd Qty: 2.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Start Date:** 

Approvals:

Process Plan:

Date:

Tooling:

Date: Date: Run

Start

Stop

Stop



Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Tool ID

Tool # Plan

Accept

Reject Qty

Reject

Insp.

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Code

Qty

Number Stamp

170

Packaging

Packaging

Identify as per dwg & Stock Location \$\int\_{0.00}\$

Memo

Memo



0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/01/31 X

W/O:			W	ORK C	RDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	ANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	Re	esolution:	Disposition	on:		QA:	V/C Clo	sed:		Date: _	
NCR:			WORK ORD	ER NO	ON-CONFORM	ANCE	(NCR)		Prod Mgr  DQA: Date:  Date:		
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# **Picklist Print**

Monday, November 15, 2010 8:35:23 AM

Work Order ID: 63807

Parent Item:

D3436-044

Parent Item N ne: Step RH



**Start Date:** 11/15/2010

Required Date: 11/22/2010

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments: IF		1□New Issue□KJ	, 513171										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3436-5 		Manufactured	No			100	Each	19.0000	4	8 <i>E</i> C	11-1	-20	
				<u>Location</u> WA	56893	Loc C	<b>Qty</b> 19 19	Loc Code		8	_		
D3436-7 		Manufactured	No		300%	100	Each	40.0000	1	$\mathcal{A}$	-	1-2	<u>ک</u>
				<u>Location</u>		Loc (		Loc Code					
03436-9		Manufactured	No	WA	56836	100	40 40 Each	6.0000	2	4	- -	<del>/ 2</del> 2	
'ad				<b>Location</b> ST056	56830	<u>Loc (</u>	<u>Qtv</u> 6 6	Loc Code		4	Ju	101/2	28
03436-4 		Manufactured	No			100	Each	4.0000	1	2 <i>E</i>	//-	-/-20	<u> </u>
				<u>Location</u> WA		Loc (	<u>Otv</u> 4	Loc Code			٠		

W/O:			WO	RK ORDER CHANG	GES				
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Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA	۱:	_ Date: _	
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NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (NCF	₹)			
DATE	STEP	Description of NC			tion B	Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section 2		Chief Eng	QC Inspector
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## **Picklist Print**

Monday, November 15, 2010 8:35:23 AM

Work Order ID: 63807

Parent Item:

D3436-044

Parent Ite:.. Name: Step RH



**Start Date:** 11/15/2010

Required Date: 11/22/2010

Page 2

Start Qty: 2.00

Required Qty: 2.00

D3436-1

Manufactured No 155

49.0000 Each

Loc Code

Clamp

**Location** 

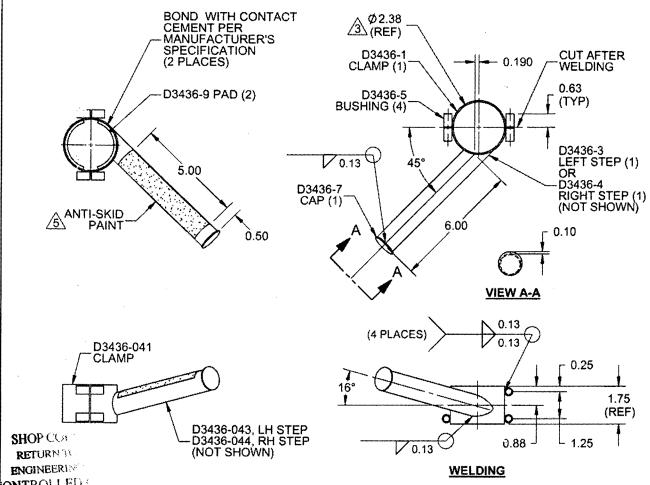
Loc Qty 49

49

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W/O:			VVC	ORK ORDER CHANGE	:5				
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	R	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)	······		
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DESIGN N	1B	DRAWN BY MB	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECK	ED#	APPROVED #	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE	05.0	)4.28	MAINTENANCE STEP	SCALE 1:4
Α	0.	5.04.28	NEW ISSUE	



UNCONTROLLED :

SUBJECT TO AMEND WITHOUT NOTIC

NOTES:

RELEASEL 05.05.27

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
  2) WELD PER DART QSI 004
  3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
  4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
  5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
  6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) APPLY BLACK ANTI-SKID PAINT A 6) TOLERANCES ARE PER DART QS 7) ALL DIMENSIONS ARE IN INCHES

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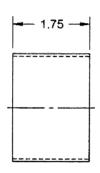
NOTE: Date & initial all entries

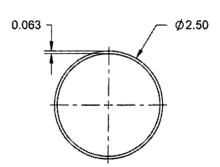
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DESIGN MB	DRAWN BY MB	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED	D3436	REV. A SHEET 2 OF 4
DATE 05.0	)4.28	MAINTENANCE STEP	SCALE 1:2

Wo 43807

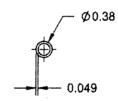




### **D3436-1 CLAMP**

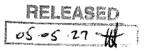
1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)





#### **D3436-5 BUSHING**

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)



### D3436-1/ -5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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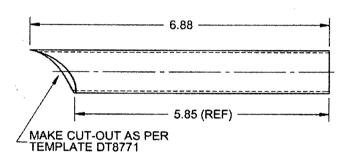
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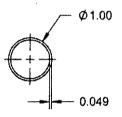
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DATE 05.0	)4.28	MAINTENANCE STEP	SCALE 1:2				

Wo 43867

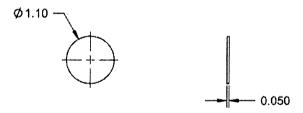




### **D3436-3 LEFT STEP**

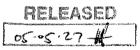
(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



#### D3436-7 CAP

MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)



## **D3436-3/-7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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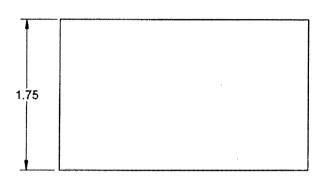
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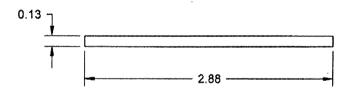
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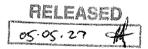


DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECKED	APPROVED #	D3436	REV. A SHEET 4 OF 4				
DATE 05.0	)4.28	MAINTENANCE STEP	SCALE 1:1				

W/s 43801







## **D3436-9 PAD**

#### NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK (REF. DART SPEC. M-NEO60-S.125)
  2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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